



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D5159-1
Job Sheet 169638



Part No: D5159-1

Job Qty: 4 ea

Part Name: Rib



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/15/17

Job Tracking No:

Due Date: 1/8/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A IPP REV:A 14.10.03 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		1/6/18	0.00	0.00	Start Up Machining-4		J.C.-L. 17-12-18
110	Cold Saw	4 pcs		1/6/18	0.00	0.62	Cold Saw		J.C.-L. 17-12-18
120	Mill Conv	4 pcs		1/6/18	0.00	5.48	Mill Conv 1		J.C.-L. 17-12-19
130	QC	4 pcs		1/6/18	0.00	0.00	QC2 Machining-3		J.C.-L. 17-12-19
140	QC	4 pcs		1/6/18	0.00	0.00	QC8 Machining-3		J.C.-L. 17-12-19
150	Powdercoat	4 pcs		1/8/18	0.00	0.08	Powdercoat3		BR 15-1-5
160	QC	4 pcs		1/8/18	0.00	0.00	QC3		BR 15-1-5
170	Packaging	4 pcs		1/8/18	0.00	0.00	Packaging3-2		BR 15-1-5
180	QC21-SA	4 Ea		1/8/18	0.00	0.00	QC21		BR 15-1-5

Part Op 110 - CUT TO BLANK

Descriptions: 120 - DRILL HOLES AND MILL ENDS AS PER DWG ***ENSURE MATERIAL SEAM IS AT THE BOTTOM OF THE PART WHERE THERE IS NO HOLES***

150 - START TIME: 3:15 O.V.T: 3:20 FINISH: 3:45.

M136370

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304TS0.750W.049	5	738	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Rib	14.700Inches ± 0.030	14.730 14.670		
2	Rib	12.790Inches ± 0.030	12.820 12.760		
3	Rib	0.950Inches ± 0.010	0.960 0.940		
4	Rib	0.266Inches ± 0.010	0.276 0.256		
5	Rib	0.297Inches ± 0.010	0.307 0.287		
6	Rib	0.400Inches ± 0.030	0.430 0.370		
7	Rib	1.000Inches ± 0.010	1.010 0.990		

DART
AEROSPACE
S024125

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Rib

PART NO: D5159-1

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 12/18/17

Job No: 169638

8	Rib	3.000Inches ± 0.010	3.010 2.990	
9	Rib	2.000Inches ± 0.010	2.010 1.990	
10	Rib	2.000Inches ± 0.010	2.010 1.990	
11	Rib	3.000Inches ± 0.010	3.010 2.990	
12	Rib	1.000Inches ± 0.010	1.010 0.990	
13	Rib	0.129Inches + 0.005 - 0.001	0.134 0.128	
14	Rib	2.440Inches ± 0.030	2.470 2.410	
15	Rib	2.625Inches ± 0.010	2.635 2.615	
16	Rib	0.129Inches + 0.005 - 0.001	0.134 0.128	
17	Rib	0.350Inches ± 0.030	0.380 0.320	Radius

Plex 12/15/17 10:36 AM dart.poulin.mario

